

# Work Order ID 52773

October 14, 2009 9:52:23 AM



Page 1

Item ID:	D3053-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	212 Basket Base Assembly					
Start Date:	14/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	28/10/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09/10/14	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3053	Rev B								

100		Large Fab	0.00					
Large Fab	Memo	0.00						
Large Fab	1-Cut 5 D2235-3 FROM D3166-1 using DT8365 □2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995							
	-Cut Ribs as per dwg							
	-Cut Mesh							
110		Large Fab	0.00					
Large Fab	Memo	0.00						
Large Fab	1-Remove all markings from material □2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required							
120		QC9- Inspect visual per QSI004- Fusion Welds	0.00					
QC	Memo	0.00						
Quality Control								

PD 09.10.20

PD 09.10.20

09/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-042 PAR #: N/A Fault Category: large fab NCR: (Yes) No DQA: bl Date: 09.11.06  
 Resolution: Rework Disposition: Rework QA: N/C Closed Date: 09.11.17

NCR: 52773		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/09	AR 100	After welding welder notices that he welded all most every thing wrong. 4 out of 5 ribs are in the wrong location. Placed the sig on the opposite side.	<i>[Signature]</i>	<del>Remove &amp; weld a new -</del> <del>D2327-3</del> Plug the affected holes on the one side, & fill with weld & grind flush per CS1004.	<i>[Signature]</i> 09.10.00	↓	<i>[Signature]</i>	S 09/10/09
		RG he didn't take the time to position the gaging in the correct orientation. LOA.	<i>[Signature]</i>	Drill the holes in the correct location (oppo side side) per the diag. Ensure no foreign objects. D2327-3 → B44274	<i>[Signature]</i> 09.10.00	S 09/10/09	<i>[Signature]</i>	S 09/10/09






NOTE: Date & initial all entries



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Item ID: D3053-042 Accept  Setup Start   
Revision ID: B Stop   
Item Name: 212 Basket Base Assembly  
Start Date: 14/10/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 28/10/2009 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC6- Inspect dimensions to drawing	0.00							
									
QC	Memo	0.00							
Quality Control									

27 50/10/09


70

0

140	DOCUMENT CONTROL	0.00							
									
DC	Memo	0.00							
Document Control	Take Traveller D205-541-043 to KP								

N/A 09/10/09

PRESSURE WASHER BR 09-10-27 D.

150	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
									
Powdercoat	Memo	0.00							
Powder Coating									

9/10/09

XC

0

1ST START TIME: 1:00pm FINISH TIME: 1:30pm OVEN TEMPERATURE: 400°F

2ND START: 200pm  
Temp: 400°C  
FIN: 2:30pm

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Item ID: D3053-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 <i>BR 09-10-28</i> 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo <i>PPP 52772</i>	0.00  0.00							<i>Cy/28</i>
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>09/10/29</i> <i>PL 09-10-28</i>

# Picklist Print

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Page 1

Work Order ID: 52773

Parent Item: D3053-042RevB

Parent Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	306.0011	50.5263			
Expanded Metal Flat SS												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

306.0011065

110134

6.7

110629

14.41

111630

9.15

111956

0.000017

112147

54.8205895

112311

28.9205

112707

192

M304TS0.750W.065

Purchased

No

100

f

678.9022

45.6140

304 SQ Tube .75x.75x.065W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

WA

678.9022

112398

678.9022

3AD 09-10-16

← 96 →

→ 8.00 → Scrap = 6.41

4.00

38.5263

PD 09.10.20

# Picklist Print

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Work Order ID: 52773



Parent Item: D3053-042RevB



Parent Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			110	Each	11.0000	2.0000			
Basket Hinge												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

8

50024

2

51870

6

Main Warehouse

WA

3

50986

3

24/10/09.10.22

D2327-3RevD

Manufactured No

110

Each

48.0000

2.0000



Spacer Bushing

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

48

44274

29

44365

9

51126

10

2 PD 09.10.20

# Picklist Print

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Work Order ID: 52773

Parent Item: D3053-042RevB

Parent Item Name: 212 Basket Base Assembly


Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			110	Each	76.0000	2.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	13	
46086	2	
48428	1	
51120	10	

Main Warehouse

WA	63	
50872	14	
51745	49	

D3166-1RevA1

Manufactured No

110

Each

22.0000

5.0000



Basket Hoop

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

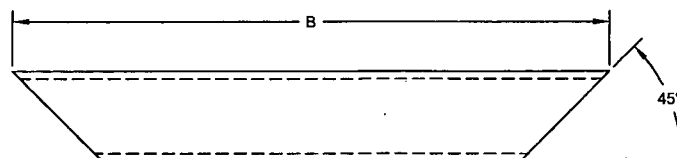
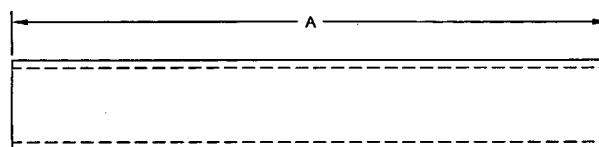
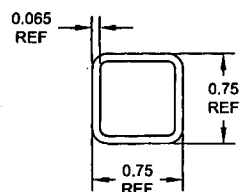
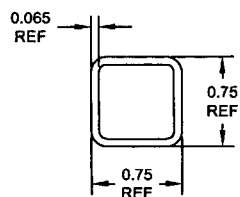
WA	22	
51248	7	
51474	3	
51951	12	

② 09.10.22

5 PD 09.10.20

# PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



B

## NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.75W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

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WORK ORDER

NO. 32723

09-10-14

RELEASED

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.02		

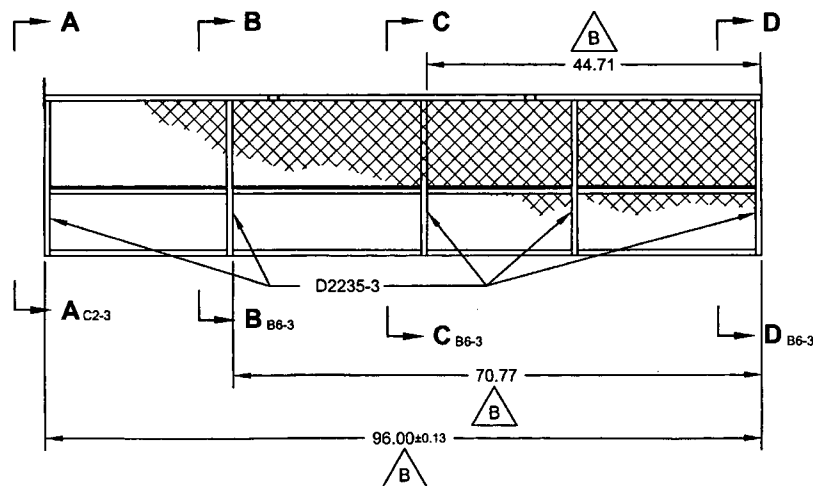
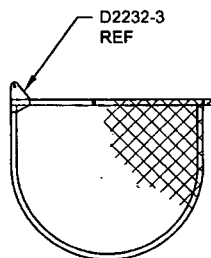
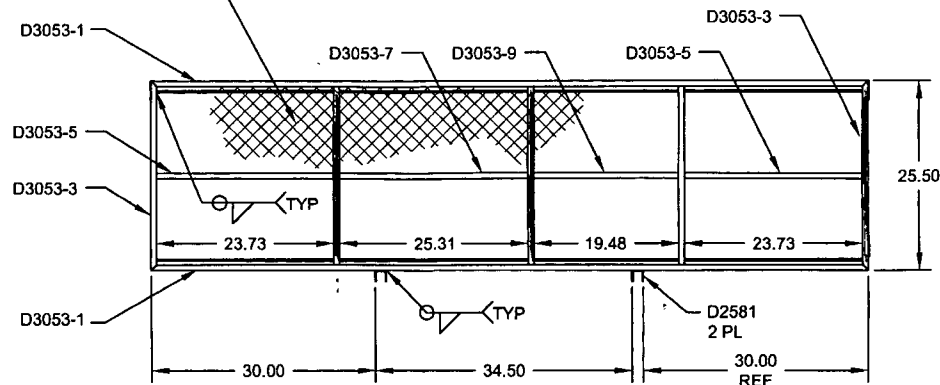
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
D3053 SHEET 1 OF 3  
TITLE SCALE  
BASKET BASE ASSEMBLY (212) NTS

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SKIN INSIDE SURFACE OF  
BASKET WITH MESH. TACK  
WELD EACH END OF STRAND  
TO FRAME

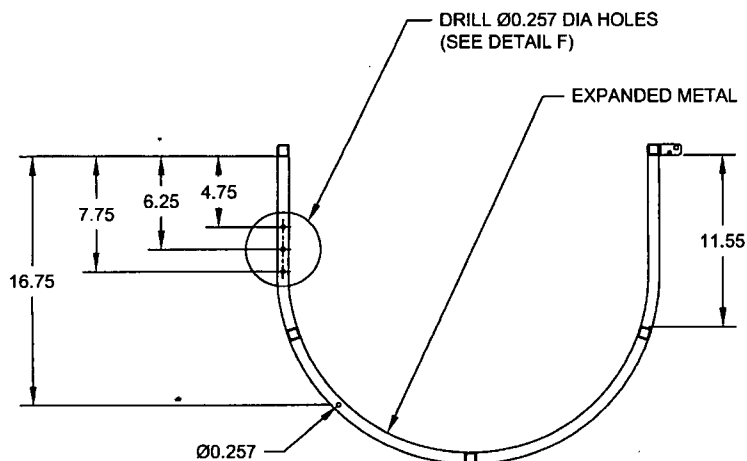


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WORK CENTER  
NO. 52773

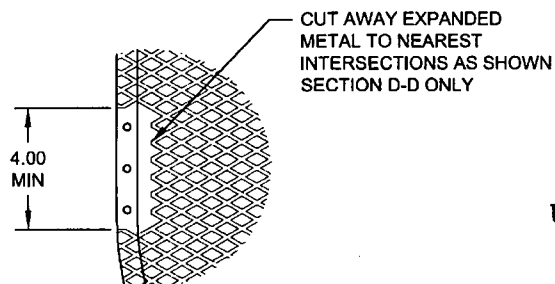
RELEASED  
08.08.12

D3053-042 BASKET BASE ASSEMBLY SHOWN  
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

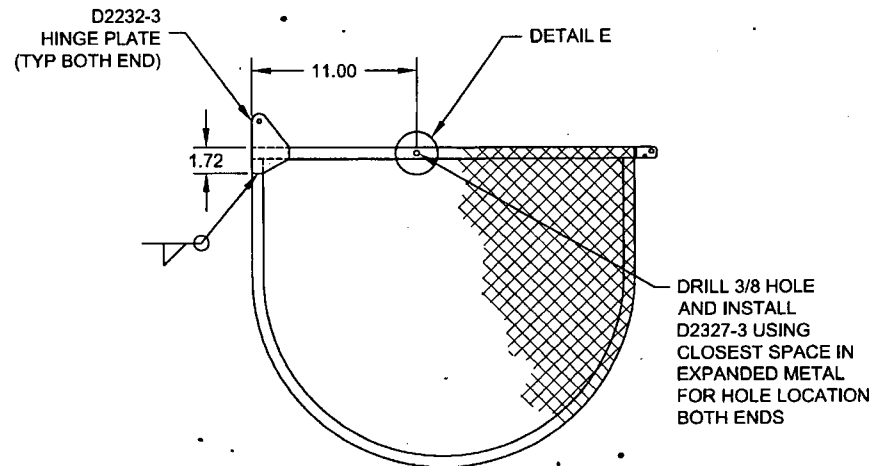
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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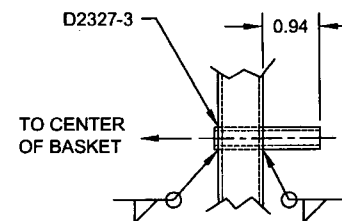
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**SECTION C-C<sub>B4-2</sub>**  
**AND SECTION D-D<sub>B3-2</sub>**  
 RIB DETAIL



**DETAIL F**  
 SCALE NONE



**SECTION A-A<sub>B6-2</sub>**  
 SPACER DETAIL



**DETAIL E**  
 SCALE 4X

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 08-05-02 MJD

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MFG. APPR.		D3053	SHEET 3 OF 3
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